



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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647.7325

Job Sheet 216147



Part No: 647.7325

Job Qty: 1 pcs

Part Name: EC135 T2/P2/T3/P3 Upper Cutter Fixed Provisions



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/30/20

Job Tracking No:

Due Date: 12/18/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 647.7300 REV.G IPP REV:A 20.06.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	12/18/20	12/18/20	0.00	0.00	Packaging 1 - SCH-S	DAS 84	
120					0.00	0.00	QC 4 - 28	84	DEC 0 8 2020
							QC 4 - 58	9-89	
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
							QC 4 - 68		
							QC 4 - 72		
							QC 4 - 74		
							QC 4 - 75		
							QC 4 - 78		
							QC 4 - 84		DEC 0 8 2020
							QC 4 - 80		
							QC 4 - 85		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/18/20	12/18/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		DEC 0 8 2020
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B	DAS 69	
							Packaging 3 - 6 - B4B	9-89	
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		
							Packaging 3 - 17 - B4B		



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Container No: S318950



Part: 647.7325

Job No: 216147

Serial No/Batch: S318950

				Packaging 3 - 18 - B4B			
				Packaging 3 - 19 - B4B			
				Packaging 3 - 20 - B4B			
				Packaging 3 - 21 - B4B			
				Packaging 3 - 22 - B4B			
				Packaging 3 - 23 - B4B			
				Packaging 3 - 24 - B4B			
				Packaging 3 - 25 - B4B			
				Packaging 3 - 26 - B4B			
				Packaging 3 - 27 - B4B			
				Packaging 3 - 28 - B4B			
				Packaging 3 - 29 - B4B			
				Packaging 3 - 30 - B4B			
				Packaging 3 - 31 - B4B			
				Packaging 3 - 32 - B4B			
				Packaging 3 - 33 - B4B			
				Packaging 3 - 34 - B4B			
				Packaging 3 - 35 - B4B			
				Packaging 3 - 36 - B4B			
				Packaging 3 - 37 - B4B			
135	DC - 1 - B4B	1 pcs	12/18/20	0.00 0.00	DC - 1 - B4B	DAS 69 9-89	DEC 08 2020
140	QC 21 - SA	1 pcs	12/18/20	0.00 0.00	DC - 2 - B4B		
					QC 21 - SA - 21	DAS 21 9-89	DEC 08 2020
					QC 21 - SA - 70		
					QC 21 - SA - 9		
					QC 21 - SA - 77		
					QC 21 - SA - 28		
Part Op 110 - Pick Kit Descriptions: 120 - QC4- 100% Inspect kits for completeness 130 - Identify and pack for shipping as per PPP 647.7325 135 - Document Control - Photocopy bluefile & type labels per PPP 647.7325 140 - QC21- Final Inspection - Work Order Release							

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	
647.2114	Upper U Channel	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7819	Cross Bracket Fwd	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7821	Eye Bolt Fitting LH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7822	Eye Bolt Fitting RH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7823	Cross Bracket Aft	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7911	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
647.7914	Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7915	Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7916	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
647.7917	Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7918	Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.8510	Insert	17 pcs (17 ea)	110-Packaging 1 - Pick Kit	
647.8512	Insert	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
CR3212-4-3	Cherry Rivet	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	
CR3212-5-3	Cherry Rivet	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	
CR3212-5-6	Cherry Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	
CR3213-5-3	Cherry Rivet	20 Ea (20 ea)	110-Packaging 1 - Pick Kit	
CR3213-5-4	Cherry Rivet	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	
CR3523-5-3	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	
MS21042-3	Nut use MS21042L3 per QSI 017	34 Ea (34 ea)	110-Packaging 1 - Pick Kit	
MS24694-S54	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	
MS27039-1-09	Screw	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	
MS27039-1-12	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS27039-1-15	Screw	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	
MS27039-1-16	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	
MS27039-1-17	Screw (601.1954)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS27039-1-18	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
NAS1149F0332P	Washer (AN960-10L)	59 Ea (59 ea)	110-Packaging 1 - Pick Kit	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0990	1	26	0
	600.0991	1	26	0
	600.1012	1	13	0
	601.2045	1	22	0
	647.2114	1	12	0
	647.7819	1	26	0
	647.7821	1	26	0
	647.7822	1	30	0
	647.7823	1	24	0
	647.7911	2	25	0
	647.7914	1	21	0
	647.7915	1	19	0
	647.7916	2	18	0
	647.7917	1	27	0
	647.7918	1	12	0
	647.8510	17	163	0
	647.8512	2	23	0
	CR3212-4-3	12	178	0
	CR3212-5-3	12	244	0
	CR3212-5-6	3	46	0
	CR3213-5-3	20	103	0
	CR3213-5-4	18	72	0
	CR3523-5-3	8	95	0
	MS21042-3	34	380	0
	MS24694-S54	5	49	0
	MS27039-1-09	12	184	0
	MS27039-1-12	2	144	0
	MS27039-1-15	1	144	0
	MS27039-1-16	4	57	0
	MS27039-1-17	2	83	0
	MS27039-1-18	2	928	0
	NAS1149F0332P	59	1,399	0
Part Specifications				
Specifications could not be found.				

Plex 11/30/20 1:56 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Fabrication

Job No: 216147

Part No: 647.7325

Sort by: ☐ Location ☒ Component

Operation	Required	Component	Description	BOM Quantity	Quantity Required	Quantity Available	Location	Container No	Serial No/Batch	Quantity Picked
110-Packaging 1 - Pick Kit	1	600.0990	Magnabond 6398 Part A Size 112 ml	1.0000	1.0000	2.0000	LG049	S314314	S314314	1
						18.0000	LG049	S314316	S314316	0
						1.0000	LG050	S314692	S306325	0
						1.0000	LG049	S315117	S314314	0
110-Packaging 1 - Pick Kit	1	600.0991	Magnabond 6398 Part B Size 112 ml	1.0000	1.0000	2.0000	LG049	S314315	S314315	0
						18.0000	LG049	S314317	S314317	0
						1.0000	LG050	S314693	S306327	0
						1.0000	LG049	S315118	S314315	1
110-Packaging 1 - Pick Kit	1	600.1012	Sealant PR1425B2 (#654 sem)	1.0000	1.0000	7.0000	CCK017	S312691	S312691	1
110-Packaging 1 - Pick Kit	1	601.2045	RTV (LOCTITE 598)	1.0000	1.0000	3.0000	Small Fab - 1	S299615	S299615	0
						3.0000	CCK095C	S304317	S304317	1
						10.0000	CCK095C	S312295	S312295	0
110-Packaging 1 - Pick Kit	1	647.2114	Upper U Channel	1.0000	1.0000	12.0000	CCK001	S248563	S248563	1
110-	1	647.7819	Cross Bracket	1.0000	1.0000	26.0000	CCK081	S230097	S136824	

Packaging 1 - Pick Kit			Fwd							1
110- Packaging 1 - Pick Kit	1	647.7821	Eye Bolt Fitting LH	1.0000	1.0000	3.0000	CCK109	S034480	S034480	0
						23.0000	CCK109	S185639	S185639	1
110- Packaging 1 - Pick Kit	1	647.7822	Eye Bolt Fitting RH	1.0000	1.0000	23.0000	CCK109	S185292	S185292	0
						7.0000	CCK109	S185297	S185297	1
110- Packaging 1 - Pick Kit	1	647.7823	Cross Bracket Aft	1.0000	1.0000	4.0000	CCK066	S024323	S024323	0
						20.0000	CCK066	S108183	S108183	1
110- Packaging 1 - Pick Kit	1	647.7911	Bracket	2.0000	2.0000	5.0000	CCK115	S101179	S101179	0
						20.0000	CCK115	S278485	S278485	2
110- Packaging 1 - Pick Kit	1	647.7914	Bracket	1.0000	1.0000	8.0000	CCK114	S026897	S026897	0
						13.0000	CCK114	S099326	S099326	1
110- Packaging 1 - Pick Kit	1	647.7915	Bracket	1.0000	1.0000	19.0000	CCK115	S099324	S099324	1
110- Packaging 1 - Pick Kit	1	647.7916	Bracket	2.0000	2.0000	1.0000	CCK116	S026966	S026966	0
						17.0000	CCK116	S100785	S100785	2
110- Packaging 1 - Pick Kit	1	647.7917	Bracket	1.0000	1.0000	27.0000	CCK122A	S103376	S103376	1
110- Packaging 1 - Pick Kit	1	647.7918	Bracket	1.0000	1.0000	12.0000	CCK116	S103809	S103809	1
110- Packaging 1 - Pick Kit	1	647.8510	Insert	17.0000	17.0000	1.0000	CCK116	S229462	S229462	0
						23.0000	CCK116	S239595	S239595	17
						139.0000	CCK116	S249792	S249792	0
110- Packaging 1 - Pick Kit	1	647.8512	Insert	2.0000	2.0000	15.0000	CCK116	S114700	S114700	0
						8.0000	CCK116	S248754	S248754	

						89.0000	ST284	S318354	S318354	5
110- Packaging 1 - Pick Kit	1	MS27039-1-09	Screw	12.0000	12.0000	18.0000	GA016	F124859	124859	0
						4.0000	FP001	F18057-1	18057	0
						15.0000	ST281	S133788	S133788	0
						111.0000	ST281	S265635	S265635	12
						188.0000	ST273F	S318347	S318347	0
110- Packaging 1 - Pick Kit	1	MS27039-1-12	Screw	2.0000	2.0000	4.0000	ST280	S231298	S231298	0
						10.0000	ST280	S285411	S285411	2
						100.0000	ST273F	S299993	S299993	0
110- Packaging 1 - Pick Kit	1	MS27039-1-15	Screw	1.0000	1.0000	15.0000	GA017	S166857	S166857	0
						76.0000	GA017	S312239	S312239	1
110- Packaging 1 - Pick Kit	1	MS27039-1-16	Screw	4.0000	4.0000	33.0000	ST280	S310415	S310415	4
						100.0000	ST273F	S318175	S318175	0
110- Packaging 1 - Pick Kit	1	MS27039-1-17	Screw (601.1954)	2.0000	2.0000	83.0000	ST280	S248039	S248039	2
110- Packaging 1 - Pick Kit	1	MS27039-1-18	Screw	2.0000	2.0000	137.0000	GA017	F124326-5	124326	2
						791.0000	ST273F	S124326-2	f124326	0
110- Packaging 1 - Pick Kit	1	NAS1149F0332P	Washer (AN960-10L)	59.0000	59.0000	2.0000	GA200	S103666-1	S103666	0
						282.0000	FP001	S216387	S216387	0
						507.0000	ST263	S309801	S309801	59
						1,000.0000	ST260A	S318170	S318170	0

										2
110-Packaging 1 - Pick Kit	1	CR3212-4-3	Cherry Rivet	12.0000	12.0000	161.0000	ST320	S307422	S307422	12
110-Packaging 1 - Pick Kit	1	CR3212-5-3	Cherry Rivet	12.0000	12.0000	4.0000	ST320	F115158	115158	0
						240.0000	CCK003	FM126333	M126333	12
110-Packaging 1 - Pick Kit	1	CR3212-5-6	Cherry Rivet	3.0000	3.0000	46.0000	ST320	F124259	F124259	3
110-Packaging 1 - Pick Kit	1	CR3213-5-3	Cherry Rivet	20.0000	20.0000	3.0000	ST319	S201487	s201487	0
						100.0000	CCK003	S316998	S316998	20
110-Packaging 1 - Pick Kit	1	CR3213-5-4	Cherry Rivet	18.0000	18.0000	7.0000	WA003-5	S226172	S226172	0
						1.0000	WA003-5	S237734	S237734	0
						54.0000	WA003-5	S264516	S264516	18
						10.0000	ST319	S287189	S287189	0
110-Packaging 1 - Pick Kit	1	CR3523-5-3	Rivet	8.0000	8.0000	15.0000	ST317	S049827	S049827	8
						4.0000	ST317	S231280	S231280	0
						76.0000	ST317	S265312	S265312	0
						100.0000	ST317	S318367	S318367	0
110-Packaging 1 - Pick Kit	1	MS21042-3	Nut use MS21042L3 per QSI 017	34.0000	34.0000	198.0000	GA011	S160258	S160258	0
						182.0000	ST304	S306113	S306113	34
110-Packaging 1 - Pick Kit	1	MS24694-S54	Screw	5.0000	5.0000	27.0000	ST284	S255161	S255161	0
						5.0000	ST284	S268679	S268679	0
						3.0000	ST284	S298106	S298106	0
						12.0000	ST284	S298402	S298402	0

C	INCORPORATED ECN 05882, 05907
D	INCORPORATED ECN 05882
E	INCORPORATED ECN 05907
F	INCORPORATED ECN 06485
G	INCORPORATED ECN 06496

A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	4	601.2045	RTV	
A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	3	600.1012	SEALANT	
A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	2	600.0991	MAGNOBOND 6398 PART B	
A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	A/R	1	600.0990	MAGNOBOND 6398 PART A	
				1									1											647.7361	T3H/P3H UPR CTR REMOVABLE PROVIS	
													1				1								647.7352	T2/P2/T3/P3/T3H/P3H SKID DEFLECTOR
																					1				647.7351	T1/P1 SKID DEFLECTOR ASSEMBLY
													1		1		1				1				647.7341	UNIVERSAL WIPER DEFLECTOR ASSEMB
1													1		1		1								647.7335	T2/P2/T3/P3/T3H/P3H LWR CTR REMOV
X																									647.7334	T2/P2/T3/P3/T3H/P3H LOWER CUTTER A
	X		1																	1					647.7333	T1/P1 LWR CTR REMOVABLE PROVISIO
1		X	1										1					1				1			647.7332	UNIVERSAL LWR CTR FIXED PROVISION
			X																						647.7331	T1/P1 LOWER CUTTER ASSEMBLY
				X																					647.7329	T3H/P3H UPPER CUTTER ASSEMBLY
					X	1									1										647.7328	T3/P3 UPR CTR REMOVABLE PROVISIO
						X																			647.7327	T3/P3 UPPER CUTTER ASSEMBLY
							X		1									1							647.7326	T2/P2 UPR CTR REMOVABLE PROVISIO
				1		1		X	1										1						647.7325	T2/P2/T3/P3 UPR CTR FIXED PROVISION
									X																647.7324	T2/P2 UPPER CUTTER ASSEMBLY
										X		1									1				647.7323	T1/P1 UPR CTR REMOVABLE PROVISIO
											X	1										1			647.7322	T1/P1 UPR CTR FIXED PROVISIONS
												X													647.7321	T1/P1 UPPER CUTTER ASSEMBLY
													X	1											647.7310	T3H/P3H REMOVABLE PROVISIONS
														X											647.7309	T3H/P3H CABLE CUTTER KIT ASSEMBLY
															X	1									647.7308	T3/P3 REMOVABLE PROVISIONS
																X									647.7307	T3/P3 CABLE CUTTER KIT ASSEMBLY
																	X		1						647.7306	T2/P2 REMOVABLE PROVISIONS
															1			X	1						647.7305	T2/P2/T3/P3 FIXED PROVISION
																			X						647.7304	T2/P2 CABLE CUTTER KIT ASSEMBLY
																				X		1			647.7303	T1/P1 REMOVABLE PROVISIONS
																					X	1			647.7302	T1/P1 FIXED PROVISIONS
																						X			647.7301	T1/P1 CABLE CUTTER KIT ASSEMBLY
334	7333	7332	7331	7329	7328	7327	7326	7325	7324	7323	7322	7321	7310	7309	7308	7307	7306	7305	7304	7303	7302	7301	FIND #	PART #	DESCRIPTION	

QTY	
NEXT ASSY (S)	ORIGINAL DATE 11/24/09 DRAWN BY CHECKER

								12			12												85	601.1065	CHERRY RIVET
		24																					84	601.3213	CHERRY RIVET
		4																					83	601.3212	CHERRY RIVET
		4																					82	601.1983	NUTPLATE RIVET
		24																					81	601.2207	NUTPLATE RIVET
		2																					80	601.3004	CAMLOC STUD
		2																					79	601.3005	CAMLOC RETAINER
		2																					78	601.3006	CAMLOC RECEPTACLE
	2				2		2			2													77	601.3128	NUT
	2				2		2			2													76	601.2669	BOLT
	2				2		2			2													75	601.2826	BOLT
		2																					74	601.2823	BOLT
																							73	601.3654	BOLT
																							72	601.3963	BOLT
																							71	601.2999	SCREW
	2				2		2			2													70	601.3127	LOCKNUT
	2				2		2			2													69	601.2280	LOCKNUT
								2			2												68	647.8512	INSERT
								17			15												67	647.8510	INSERT
										1													66	647.7919	SHIM
								1			1												65	647.7918	BRACKET
								1			1												64	647.7917	BRACKET
								2			2												63	647.7916	BRACKET
								1			1												62	647.7915	BRACKET
								1			1												61	647.7914	BRACKET
		2																					60	647.7913	DOUBLER
		4																					59	647.7912	CLIP
								2			2												58	647.7911	BRACKET
		2																					57	647.7910	ANGLE BACKET
								1															56	647.7823	CROSS BRACKET AFT
								1			1												55	647.7822	EYE BOLT FITTING RH
								1			1												54	647.7821	EYE BOLT FITTING LH
											1												53	647.7820	CROSS BRACKET AFT
								1			1												52	647.7819	CROSS BRACKET FWD
											1												51	647.7818	MOUNTING CHANNEL
	2																						50	647.7702	LOWER STRUT
					2		2			2													49	647.7701	UPPER STRUT
	1																						48	647.7501	LOWER CUTTER ASSY
										1													47	647.7401	UPPER CUTTER ASSY
334	7333	7332	7331	7329	7328	7327	7326	7325	7324	7323	7322	7321	7310	7309	7308	7307	7306	7305	7304	7303	7302	7301	FIND #	PART #	DESCRIPTION

PROVISIONS ARE INSTALLED. F/N 26 & F/N 70 ARE NOT INSTALLED IF OEM PROVISIONS ARE INSTALLED.

ORIGINAL DATE (MO-DA-YR)	11/24/09
DRAWN BY	CHECKER